

Work Order ID 83345

April-17-12 2:17:43 PM

83345

Page 1

Item ID: D3943-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Stud

Stop ***NS2***

Start Date: 17/04/2012 Start Qty: 16.00

16

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/17

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3943	E								

100

0.00

100

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER DWG AND FOLIO FA864

FOLIO REV: _____

DWG REV: _____

2-DEBURR AS REQUIRED

*****TAP DRILL FOR 1/4"-20 IN CENTER OF PART*****

Manual

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Handwritten signature

12/4/12

18

130

Identify as per dwg & Stock Location: 074

0.00

130

Packaging

Memo

0.00

Packaging

18

12/04/2012

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/2012

ME 12-04-20

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Picklist Print

April-17-12 2:17:47 PM

Page 1

Work Order ID: 83345

83345

Parent Item: D3943-7

D3943-7

Parent Item Name: Stud

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 16.00

Required Qty: 16.00

Comments:

Est Rev:A New Issue 09-06-03 JLM Verified By:EC IPP Rev:B
as per dwg REV.C DD 10.02.22 verified by:EC IPP REV:C 11.08.16
AS PER REV.E DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010R0.375		Purchased	No			100	f	8.8600	0.02	0.336842			

M1010R0.375

ROUND BAR .375

**

Location

MAT038

Loc Qty

8.86

8.86

Loc Code

112886

.5 12-4-19

Dart Aerospace Ltd

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ITEM No.	QTY -041	QTY -051	QTY -053	PART NUMBER	DESCRIPTION	PREFERED SUPPLIER
1	X			D3943-041	GROUND HANDLING CRANK ASSEMBLY	
5	1	X		D3943-051	HANDLE ASSEMBLY	
6	1		X	D3943-053	CHAIN ASSEMBLY	
11		1		D3943-1	HANDLE	M/F HANDLE FROM DIS-ASSEMBLED ITEM 39
12	1			D3943-3	HANDLE EXTENSION	
13		1		D3943-5	PLATE	
14		2		D3943-7	STUD	
15			1	D3943-9	CHAIN	USE CHAIN SUPPLIED WITH ITEM 39
16			1	D4405-1	EYE AND FORK SWIVEL	
21	1			D2690-4	LANYARD	
22	1			D3585-1	SET SCREW	
23	1			D3949-041	REMOVE BEFORE FLIGHT FLAG	
24			1	D3954-5	CHAIN LUG	
25	1			D3954-7	RATCHET LUG	
26			1	D3954-9	GWT CHAIN PIN	
31	1			AN5-11A	BOLT	
32	1			AN960-516	WASHER	
33	1			MS21042L5	NUT	
39	1			8143919	LEVER CHAIN HOIST (POWER FIST)	PRINCESS AUTO / 4000 lbs CAPACITY
51	1			S-1475	SPRING	REID SUPPLY
52	1			3408A59	BALL PLUNGER	McMASTER CARR
53	1			HX-15	SOCKET HEAD CAP SCREW 1/4-20 UNC X 0.75 LG	HASKINS
54	1			HX-16	SOCKET HEAD CAP SCREW 1/4-20 UNC X 1.0 LG	HASKINS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 83345-405

12/04/17

RELEASED
2011-07-29

E	CHANGED D3945-3 MAT'L TO SS (B8-5); FINISH NOW "NONE" (A7-5); TAP DRILL FOR 1/4-20 UNF-28 WAS PILOT HOLE NOTE (B1-5). PER PAR11-113.	MB	11.07.27
D	SHT 1 PL, ITEMS 51-54 RENUMBERED SEE PREV. REV. FOR DETAILS, ITEM 16 ADDED (VIEWS UPDATED). SHT 2 ZN D3 FLAG RELOCATED. SHT 3 ZONE D3, Ø0.12 HOLE DELETED. (SEE NCR 11-495)	AJS	11.05.16
C	RMV FINISH -041 (ZN A8-2), ADD NEW FINISH -051/-053/-1/-3 (A8-3/-4/-5), ADD CALIBRATION (A8-2), (1) HX-16 WAS HX-15 (B3-1, C3-1), PAR 10-001	CP	10.01.26
B	SHT 1 PL, ITEM 31 WAS AN4-10A, ITEM 32 WAS AN960-416, ITEM 33 WAS MS21042-4, ITEM 43 WAS 0.75 LG. SHEETS 2 - 5 NOTES: FINISH FOR ALL COMPONENTS NOW YELLOW SPRAY PAINT.	AJS	09.10.15
A	NEW ISSUE	AJS	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	DSTON / AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	N/A	GROSS WEIGHT TOW CRANK ASSY	NTS
DATE	11.07.27	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

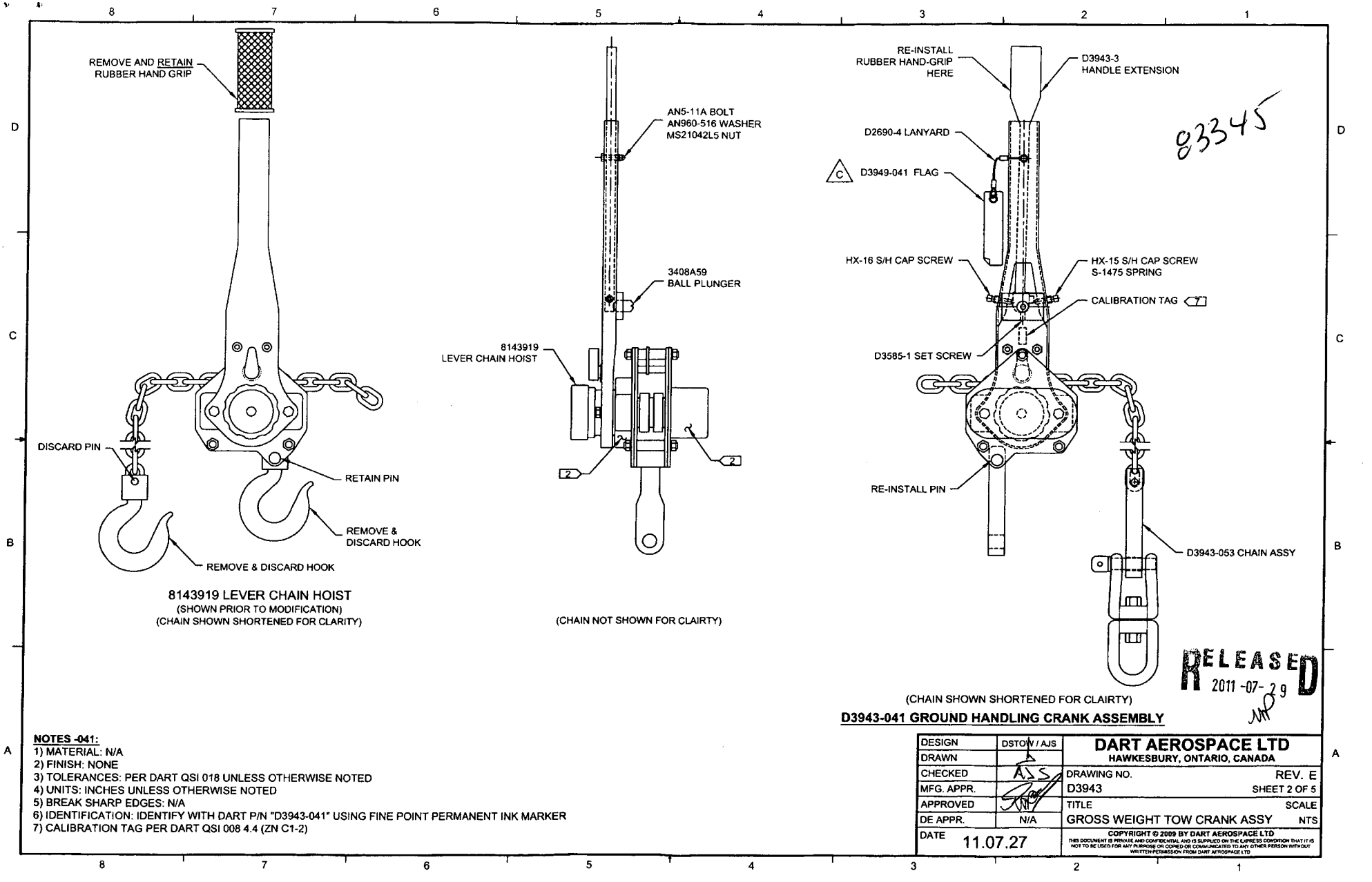
W/O:		WORK ORDER CHANGES					
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D3943-1 HANDLE

2 PL

9.75

2.00

Ø0.31
THRUD3943-7 STUD
2 PLTHREAD $\frac{1}{2}$ -20 UNC-2B
THRUVIEW A-A
A5-3
(SCALE 2X) B5-3

2 PL

9.38
REF

A B1-3

D3943-5 PLATE

D3943-051 HANDLE ASSEMBLY**NOTES -051:**

- 1) MATERIAL : N/A
- 2) FINISH: POWDER COAT HYBRID SAFETY YELLOW (4.3.5.12) PER DART QSI 005 4.3
- 3) TOLERANCES: X.XX DIMENSIONS +/- 0.06 ALL OTHERS
PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) MASK ALL THREADS PRIOR TO FINISHING

DESIGN	DSTOW / AJS	DART AEROSPACE LTD	
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CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D3943	SHEET 3 OF 5
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DE APPR.		GROSS WEIGHT TOW CRANK ASSY	NTS
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2011-07-28
MM

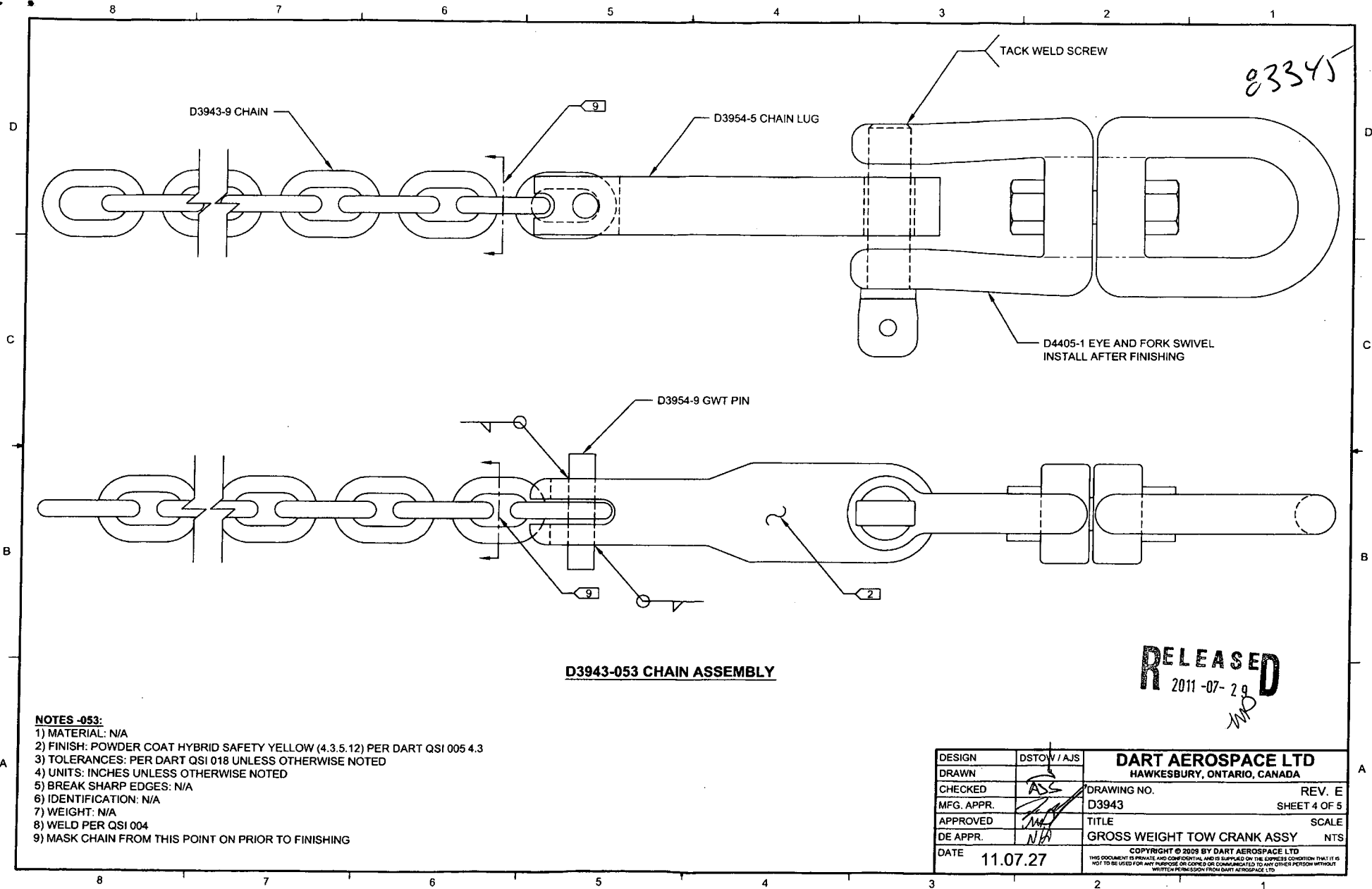
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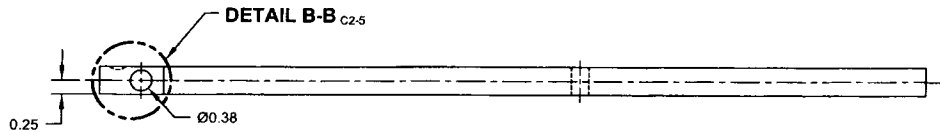
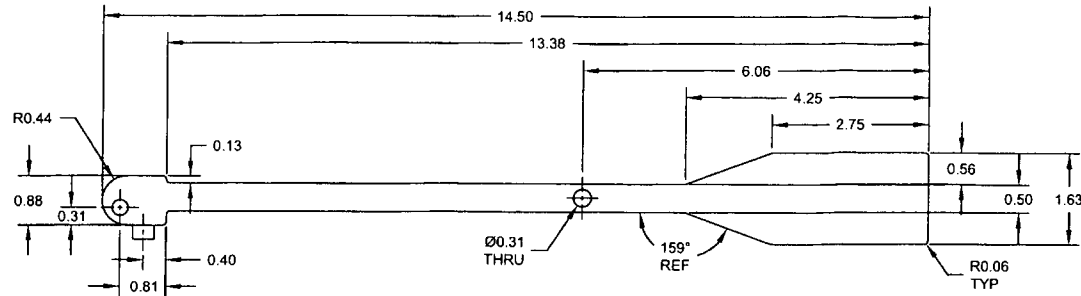
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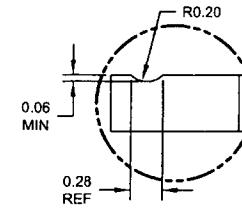
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8 7 6 5 4 3 2 1



D3943-3 HANDLE EXTENSION



DETAIL B-B C7-5
(DIMPLE DETAIL)
(SCALE 2X)

NOTES:

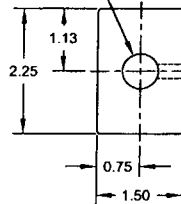
1) MATERIAL -3: AISI 304/316 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S
OR:
AISI 303 STAINLESS STEEL SHEET
ANNEALED 2B FINISH PER MIL-S-5059
ASTM A240 OR ASME SA240
REF DART SPEC M303S

-5: MILD STEEL, SHEET
AISI 1010-1025 OR ASTM A36/A366/A1008
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-S
OR:
MILD STEEL, BAR
AISI 1010-1025 OR ASTM A36/A366/A569/A570
OR CSA G40-21, 38W/44W/50W/60W/70W
REF DART SPEC M1010-B

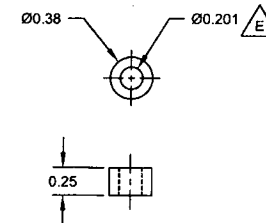
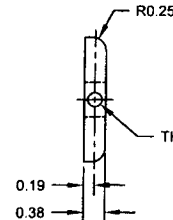
-7: MILD STEEL, ROUND BAR
AISI 1018-1025
PER MIL-S-7097
REF DART SPEC M1018-R

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A

THREAD $\frac{1}{8}$ -11 UNC-2B



D3943-5 PLATE



D3943-7 STUD
(SCALE 2X)

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2011-07-28

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MFG. APPR.	<i>WBS</i>	D3943	SHEET 5 OF 5
APPROVED	<i>WBS</i>	TITLE	SCALE
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